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# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9868	27/40
2	Machined By		N.T.L n/c Shop	Dy. H. Lark 9109 STD
3	Pallet Die No.		10361 (3.2) n/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	399.9 n/c Step OD: 395 n/c	Step length = 4.5
6	Inside Diameter	Drg. No.	320.12 n/c	
7	Width of Pellet Die	Drg. No.	142 n/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 n/c   15.5 x 7 x 2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	Tapping No. of holes = 8 Both Side
12	Tapping PCD		355 n/c	
13	Tapping Hole Diameter		M16 x Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/c Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 12/7/23

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No - 3 Hole Colused (D)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok								Ron-19
2	External Relief Dia	3.5 n/c	outside (2-2)		inner					
3	External Relief Depth		16 n/c		13 n/c					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date		12	7	23					

**Inspected By (Sign) & Date**

Ravi 12/7/23

Reviewed by (Engineer-CNC)

Manager-QA